

Date: Wednesday, 6/6/2007 1:48:05 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING  
 Job Number : 32774  
 Estimate Number : 10336  
 P.O. Number : *N/A* Part Number : D2807  
 This Issue : 6/6/2007 S.O. No. : *N/A* Drawing Number : D2807 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 29827 Material : *N/A*  
 Due Date : 6/25/2007 Qty: 50 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est: D 05.06.21 Removed painting; Changed supplier  
 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *3926*

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

*C267106107*  
*(50)*

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
 SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*[Signature]*  
*07/07/08*  
*(50)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*checked last time for all*  
*shakes*  
*En 07/07/08*

*counted*  
*(50)*

5.0 D28073



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: *B 29831*

*FF 07-08-09*

*45*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/03/24	1	Remove the inspection sheet from D2807 should be only 3 Aug.	SB	07/03/24				
07/03/24	6	Split u/o	SB	07/03/24	45			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:48:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 32774

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

FF 07-08-10

FF 07-08-27

45

45

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 10/06/08 (45)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Ep 07/08/29 (45)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(45)

Comment: FINAL INSPECTION/W/O RELEASE

12/07/08/29

Job Completion



Li 07-08-29



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

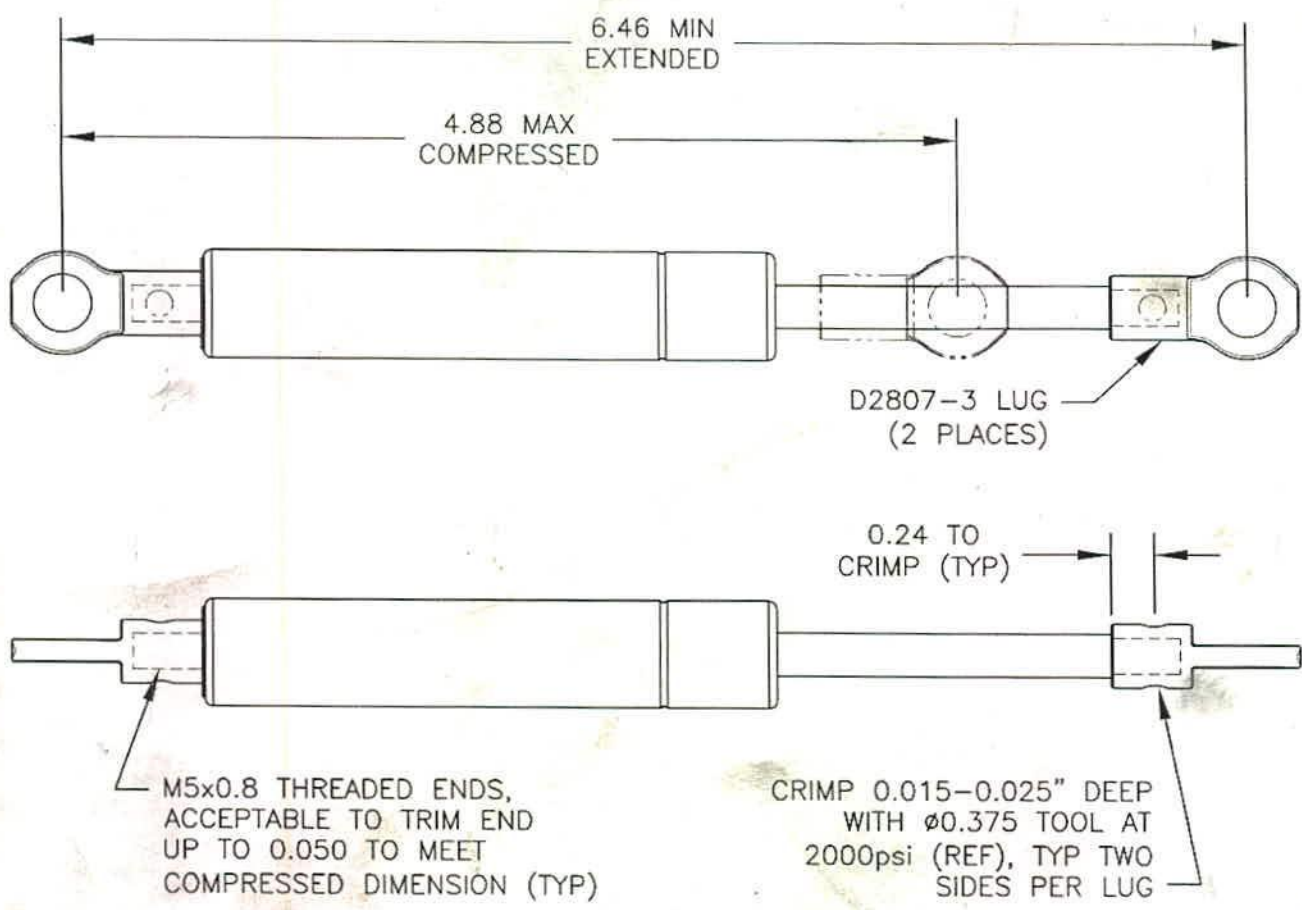
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

RELEASED  
# 05.06.16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. C
DATE	05.05.25	DRAWING NO.	D2807	SHEET 1 OF 2
		TITLE	GAS SPRING	SCALE
				1:1
A		00.11.03	NEW ISSUE	
B		05.03.16	ADD FINISH	
C		05.05.25	CHANGE SPRING TO SS, ADD -3 LUG	



**D2807 GAS SPRING**

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS
- POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

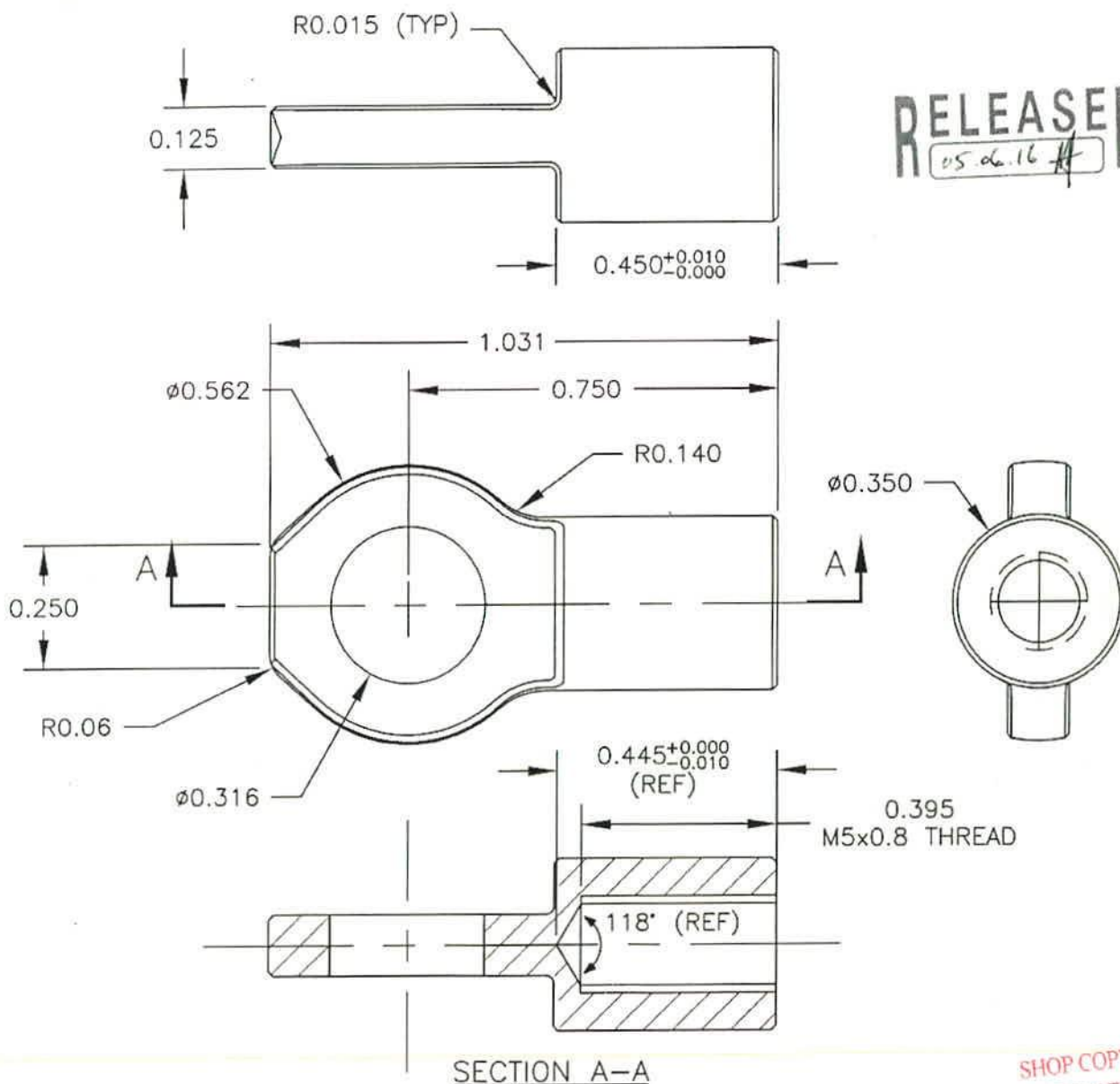
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES  $0.010$  TO  $0.015$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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## SALES INVOICE

<b>ArvinMeritor</b>  <b>Invoice To:</b> Dart Aerospace Limited 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada	<b>VAT Registration Number : 738857771</b>   FM 229  <b>Deliver To: If different from Invoice To address.</b> <b>AS INVOICE ADDRESS</b> ..... *** 1 CARTONS *** 3.90 kgs ** *****BTN NO 8708-9980-80 (SPRINGS)***** Dims1 @ 30x20x20cms	<b>Invoice No:</b> 61628  <b>Date : 27/06/2007</b>  <b>A/C Number</b> 20111  <b>Customer Ref :</b>
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[illegible]

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INVESTOR IN PEOPLE

CUSTOMER REF. No.  
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V.A.T. REGISTRATION No. GB 738 8577 7

Cam 001

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